



Dart Aerospace Ltd.
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Tel (613) 632-5200

D3641-4
Job Sheet 180855



Part No: D3641-4

Job Qty: 12 ea

Part Name: Cover RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Waterjet		SC 8/15/18
100	Waterjet	12 pcs	8/10/18	8/10/18	0.00	0.78	Waterjet1		SC 8/15/18
110	QC	12 pcs	8/10/18	8/10/18	0.00	0.00	QC2 Waterjet-2		SC 8/15/18
120	QC	12 pcs	8/10/18	8/10/18	0.00	0.00	QC8-3		38
130	Brake NC	12 pcs	8/10/18	8/10/18	0.00	0.51	Brake NC 1		3-89
140	QC	12 pcs	8/10/18	8/10/18	0.07	0.00	QC5		AUG 17 2018
150	HandFinish	12 pcs	8/10/18	8/10/18	0.00	0.75	HandFinish1		D.R. 18/10/18
160	QC	12 pcs	8/10/18	8/10/18	0.00	0.00	QC7-2		AUG 20 2018
170	Packaging	12 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3-1		5/23/18
180	QC21-SA	12 Ea	8/10/18	8/10/18	0.00	0.00	QC21		AUG 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.032	5052-H32 .032 Sheet	9.4212 sf (.7851 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.032	9	77	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected U		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Part: D3641 - 4 Job No: 180855 Serial No/Batch: S094829 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/22/18			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐					
OTHER : _____		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Wrong ☐ tensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					

DART AEROSPACE LTD		Work Order: 180855
Description: Cover		Part Number: D3641-4
Inspection Dwg: D3641	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.191	1		15C-01	
12.41	+/-0.030	12.40	1		Tape	
22.41	+/-0.030	22.40	1			
24.00	+/-0.030	24.00	1			
0.50	+/-0.030	0.50	1			
4.78	+/-0.030	4.79	1			
Grain Along 4.70	N/A	good	1			

Measured by: SC	Audited by: DAS	Preliminary Approval:
Date: 18/07/21	Date: JUL 24 2018	Date:

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	
C	09.09.15	Dimensions updated	KJ	
D	12.03.08	Dwg Rev updated	KJ	

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